

NOTES:

1. ALL DIMENSIONS ARE IN mm.
2. ALL PLATES ABOVE 20mm THICK SHALL BE UT TESTED.
3. ALL WELDS ARE OF 10mm SIZE FILLET UNLESS OTHERWISE SPECIFIED.
4. STRESS RELIEVING IS TO BE CARRIED OUT AFTER COMPLETION OF ALL WELDING & BEFORE MACHINING.
5. UNLESS OTHERWISE SPECIFIED, ALL WELDING SHALL BE SUBJECTED TO THE FOLLOWING TESTS:
 - 5.1. 100% MT/PT FOR FILLET WELDS AFTER FINAL PASS.
 - 5.2. 100% PT FOR GROOVE WELDS AFTER ROOT PASS AND FINAL PASS.
 - 5.3. 100% UT/ RT FOR GROOVE WELDS AFTER FINAL PASS
6. ALL DIMENSIONS SPECIFIED IN THIS DRAWING ARE FINAL DIMENSIONS WHICH ARE TO BE ACHIEVED AFTER FINISH MACHINING.
7. ALL MATING SURFACES, BORES AND THREADED HOLES SHALL BE GREASED. THE REMAINING EXPOSED SURFACES SHALL BE PAINTED AS PER THE INSTRUCTIONS STATED IN SPECIFICATION.
8. BILL OF MATERIAL SHOWS THE FINISHED SIZES OF PLATES, BARS AND OTHER SECTIONS. FOR MATERIAL PROCUREMENT, NECESSARY FABRICATION & MACHINING ALLOWANCE SHALL BE ADDED AS PER EXISTING SHOP PRACTICES.
9. OVERALL SIZES OF ITEMS ARE INDICATED IN THE BILL OF MATERIAL. BASED ON AVAILABILITY OF PLATE SIZES AND REQUIRED SHAPE, THE ITEMS MAY BE FABRICATED FROM INDIVIDUAL PLATES WELDED TOGETHER. HOWEVER FULL PENETRATION BUTT WELDS WITH 100% RADIOGRAPHY IS TO BE CARRIED OUT FOR ALL THESE JOINTS. THE VENDOR SHALL OBTAIN PRIOR APPROVAL FROM THE PURCHASER FOR THE CONFIGURATION AND LOCATION OF ALL SUCH ADDITIONAL BUTT WELDED JOINTS THAT ARE PROPOSED TO BE CARRIED OUT BY HIM.
10. USE TEMPLATES FOR MARKING AND DRILLING HOLES. THE SAME TEMPLATE IS TO BE USED FOR DRILLING HOLES IN ALL MATING COMPONENTS.
11. LIFTING LUGS ARE TO BE PROVIDED BY THE VENDOR FOR HANDLING THE MODULES AT SHOP AND AT SITE. THE LIFTING LUGS SHALL BE REMOVED FROM THE MODULES AFTER COMPLETION OF THE WELDING OF THE MODULES AT SITE. THE LUGS SHALL BE REMOVED WITHOUT DAMAGING THE PARENT PLATES AND ANY PROJECTION OR ROUGH SURFACE FOUND IS TO BE GROUND SMOOTH AND PAINTED.

TOTAL WEIGHT 299407 kg(Approx.)					
4	INTERFACE RING	-	1	804	REFER SHEET NO : 14 OF 14
3	GROUND ANCHOR	-	4	4144	REFER SHEET NO : 13 OF 14
2	UMBILICAL TOWER (UT)	-	1	48787	REFER SHEET NO : 10 OF 14
1	MOBILE LAUNCH PEDESTAL(MLP)	-	1	245672	REFER SHEET NO : 2 OF 14
S.NO	DESCRIPTION	MATERIAL	QTY	W.T	REMARKS

	STATUS	SIGN	DATE
	DISCUSSION / REVIEW		
✓	TENDER PURPOSE	(Signature)	09/10/20
	FABRICATION		
UNRESTRICTED	RESTRICTED	CONFIDENTIAL	
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DO NOT SCALE THE DRAWING
ASK IF IN DOUBT
UNLESS OTHERWISE SHOWN
ALL DIMENSIONS ARE IN MILLIMETERS
REMOVE SHARP EDGES & BURRS
CHAMFER 1 M.M. X 45°
MACHINING FINISH IN MICRONS :-
▽ 8 - 25 ▽ 1.6 - 8
▽▽ 0.025 - 1.6 ▽▽▽ < 0.025

DEVIATION FOR NON TOLERANCED DIMENSIONS (IS -2102)	
DIAMETERS & LENGTHS	LENGTH IN M.M. OF SHORTER SIDE OF ANGLE UPTO & INCL.
UPTO & INCL. 6 ± 0.1	
6 - 30 ± 0.2	
30 - 120 ± 0.3	
120 - 315 ± 0.5	1 - 6 $\pm 1^{\circ}-0'$
315 - 1000 ± 0.8	6 - 30 $\pm 0^{\circ}-3'$
1000 - 2000 ± 1.2	30-120 $\pm 0^{\circ}-2'$
2000 - 4000 ± 2.0	120-400 $\pm 0^{\circ}-1'$
4000 & ABOVE ± 3.0	


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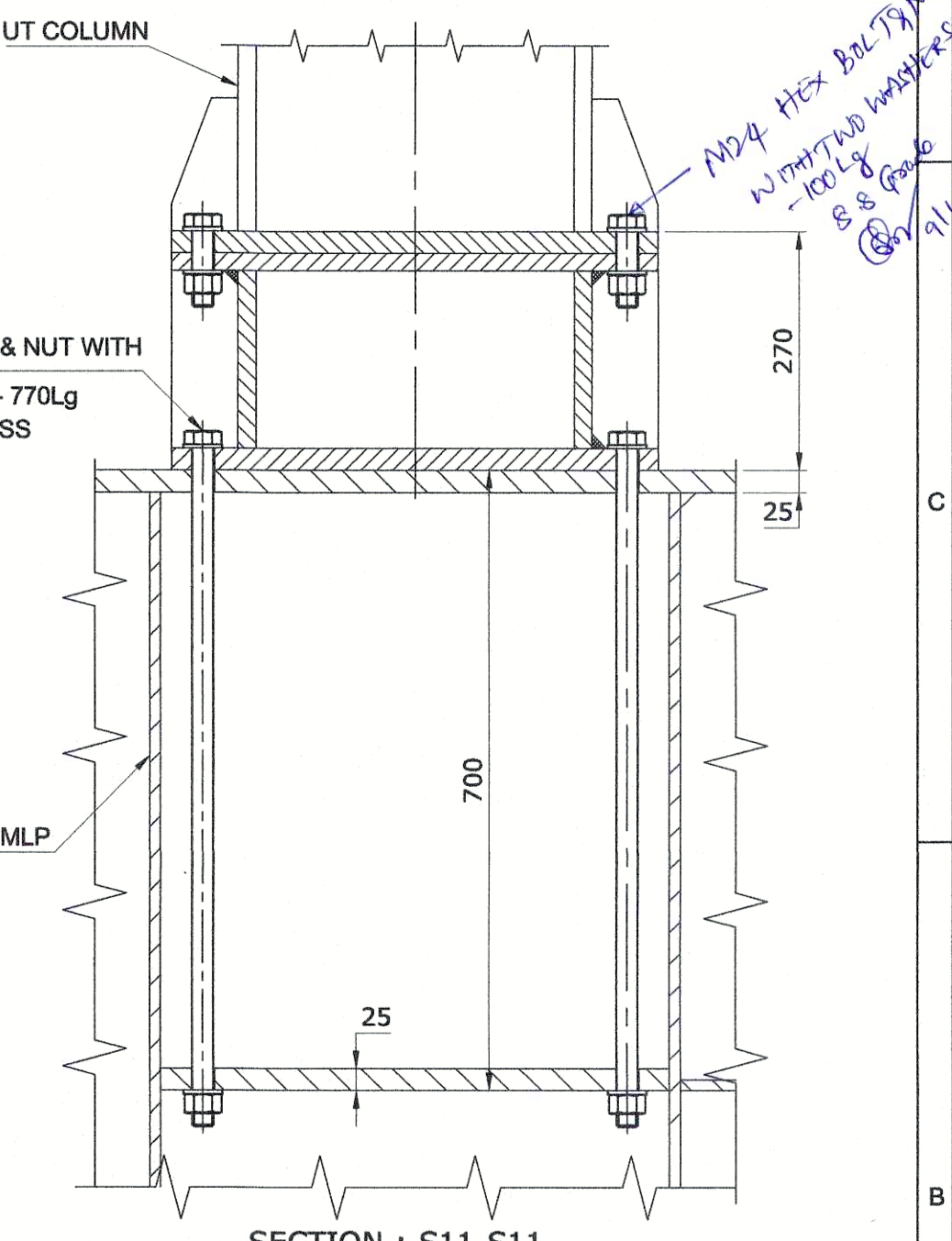
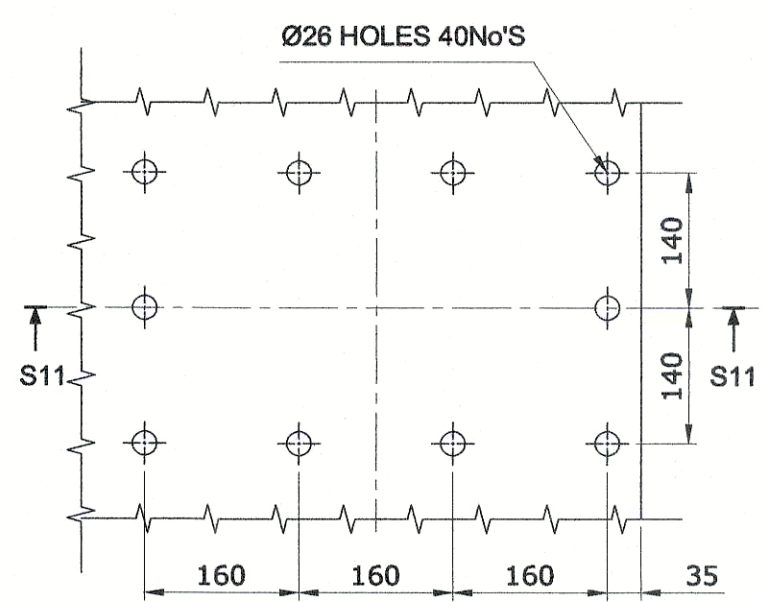
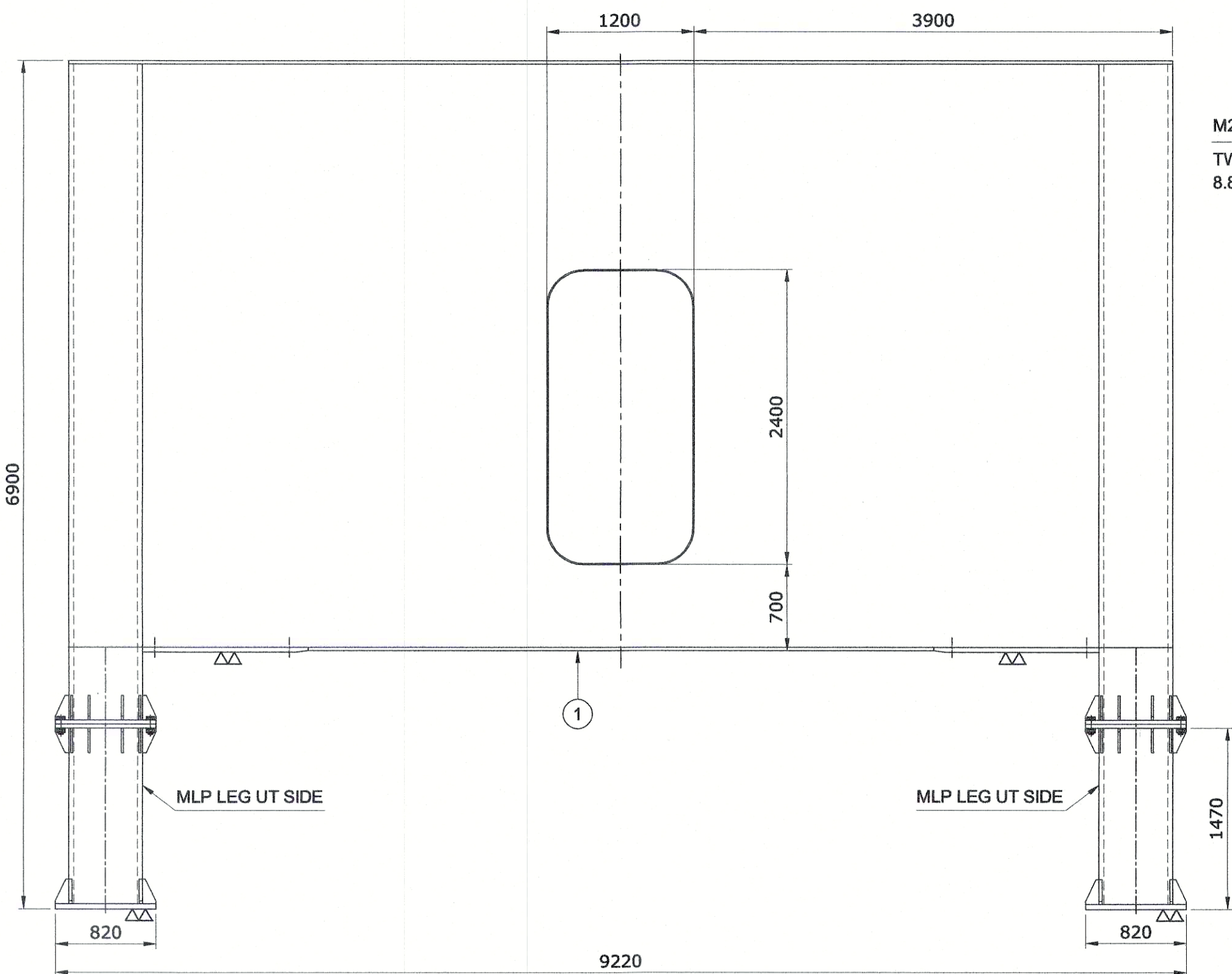
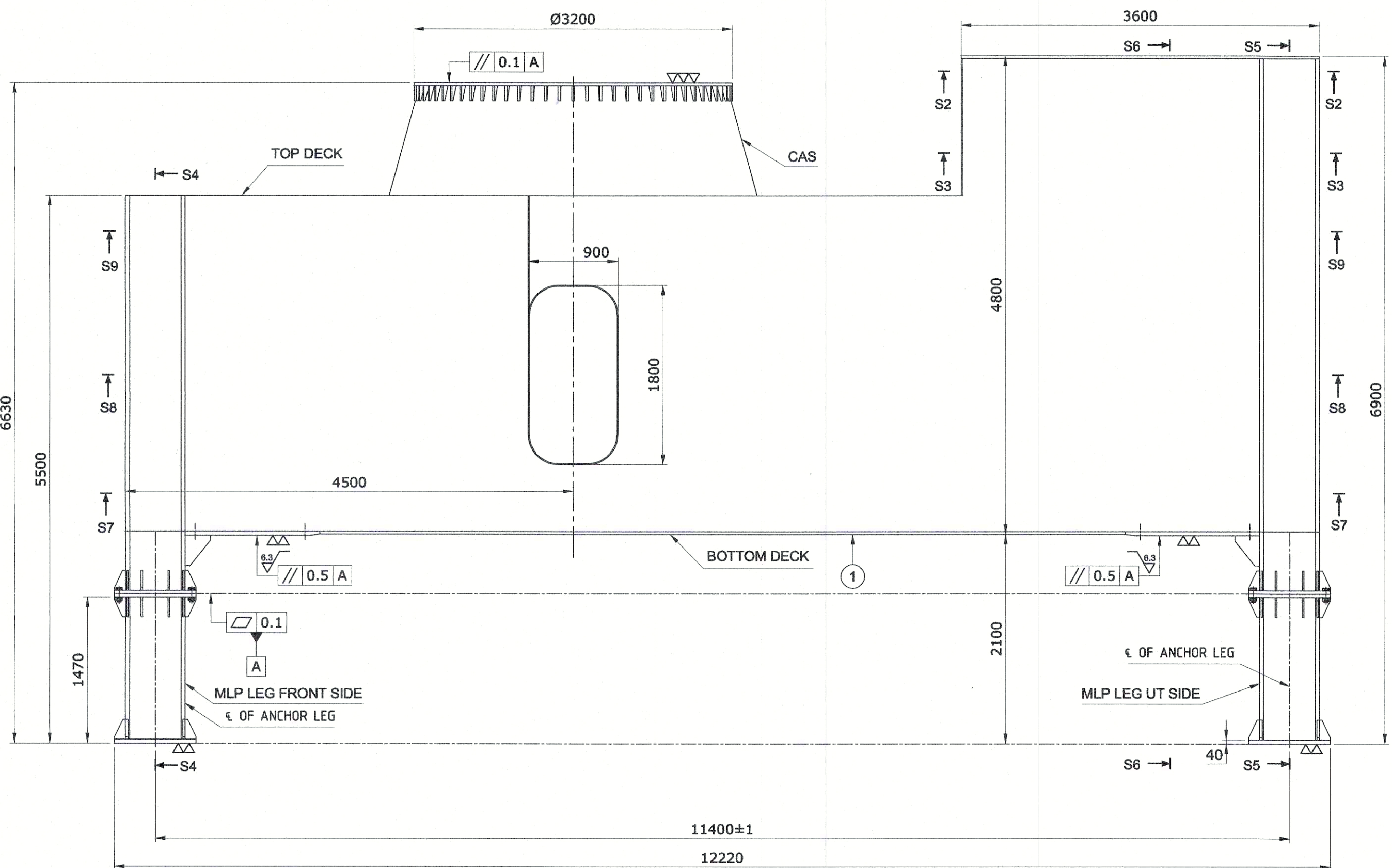
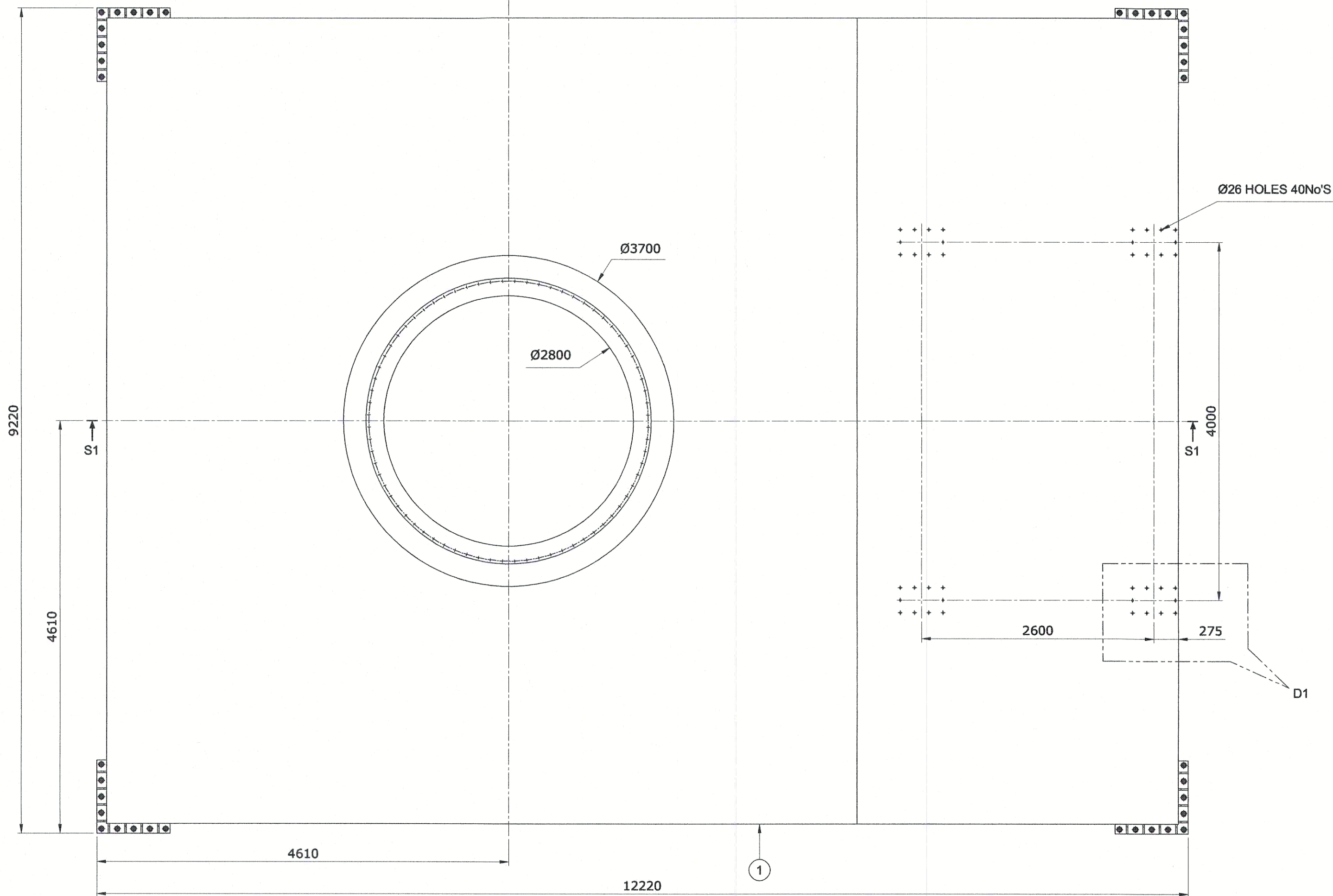
SHAR CENTRAL DESIGNS		
DESIGNED	<i>[Signature]</i>	9/10/23
DES.CHKD	<i>[Signature]</i>	
DRAWN	REENU.P	09-10-23
DRG.CHKD	<i>[Signature]</i>	9/10/23
APPROVED	<i>[Signature]</i>	
	SIGN.	DATE

TITLE	GENERAL ASSEMBLY OF MOBILE LAUNCH STRUCTURE (MLS) (SLC PROJECT)
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**GOVERNMENT OF INDIA
INDIAN SPACE RESEARCH ORGANISATION
SATISH DHAWAN SPACE CENTRE SHAR
SRIHARIKOTA**

SCALE 1 : 25	DRG. NO. 10-STR-12-1-23/A1
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PROJECTION	A
	
SHEET 1	
OF 14	



NOTES:

- ALL DIMENSIONS ARE IN mm.
- ALL WELDINGS SHALL BE CARRIED OUT AS PER IS:9595.
- STRESS RELIEVING IS TO BE CARRIED OUT AFTER COMPLETION OF ALL WELDING & BEFORE MACHINING.
- UNLESS OTHERWISE SPECIFIED, ALL WELDING SHALL BE SUBJECTED TO THE FOLLOWING TESTS:
 - 100% MT/PT FOR FILLET WELDS AFTER FINAL PASS.
 - 100% PT FOR GROOVE WELDS AFTER ROOT PASS AND FINAL PASS.
 - 100% UT/ RT FOR GROOVE WELDS AFTER FINAL PASS
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- USE TEMPLATES FOR MARKING AND DRILLING HOLES. THE SAME TEMPLATE IS TO BE USED FOR DRILLING HOLES IN ALL MATING COMPONENTS.
- STRUCTURE SHALL BE PAINTED AS PER THE PURCHASE ORDER.
- DETAILED FABRICATION DRAWINGS SHALL BE PREPARED BY THE FABRICATOR AND APPROVED BY THE DEPARTMENT BEFORE STARTING FABRICATION.**
- REMOVABLE HAND RAILS(HEIGHT:1160, PIPE 32 NB, SCHE:40) SHALL BE PROVIDED ON THE CIRCUMFERENCE(4 X 9m) OF TOP OF THE MLP.
- APPROACH LADDERS(FOUR NUMBERS) SHALL BE PROVIDED TO REACH TO TOP OF MLP.
- FOR SECTION DETAILS REFER SHEET NO : 3 OF 12 TO 7 OF 12.
- CHECK THE STATUS OF THE DRAWING BEFORE STARTING FABRICATIONS.

TOTAL WEIGHT 245672 kg(Approx.)

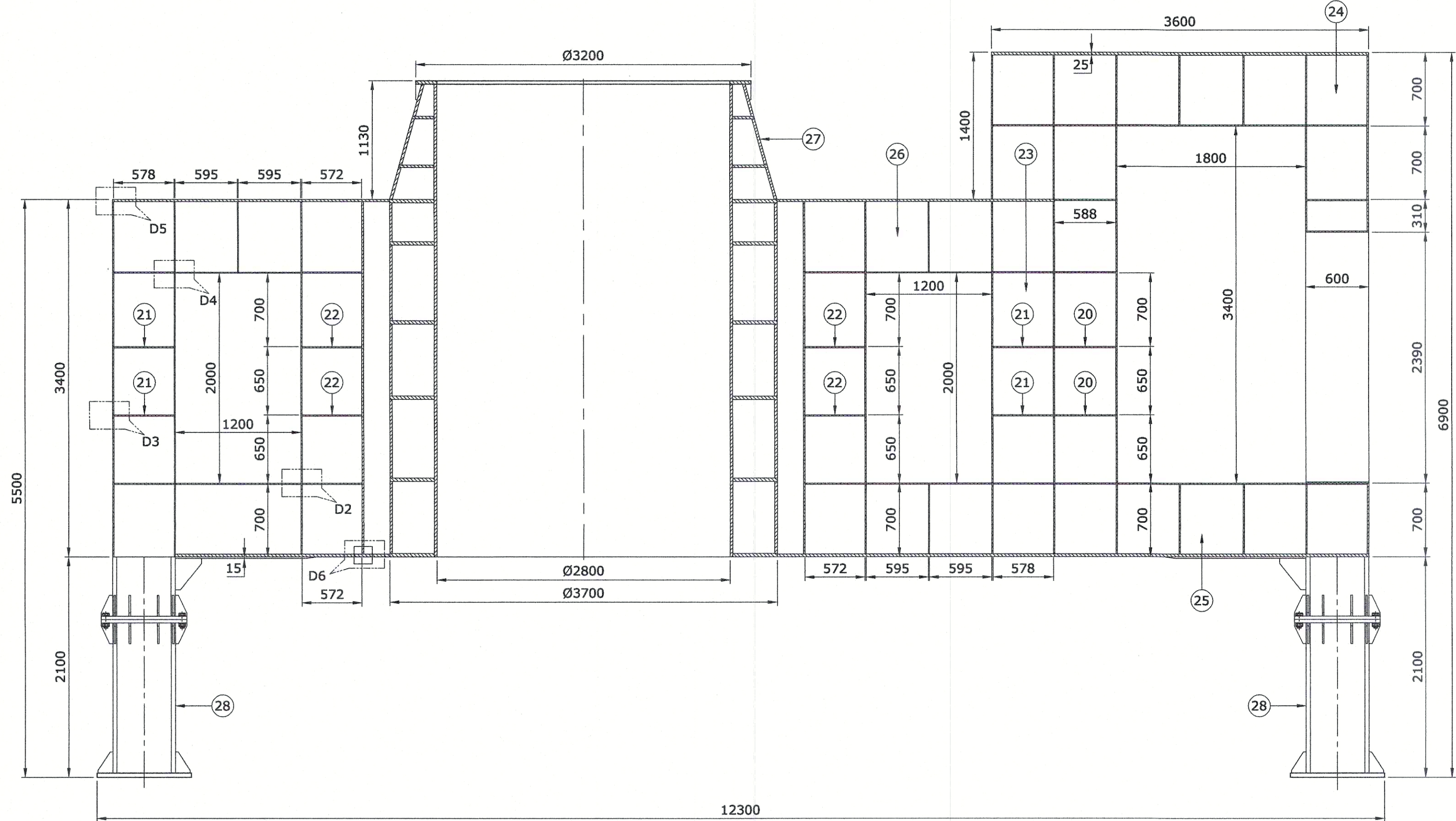
S.NO	DESCRIPTION	MATERIAL	QTY	W.T	REMARKS
1	DETAILS OF MLP FOR MLS- 1	-	1	245672	

DESIGNED	DRG. CHKD	APPROVED	SIGN.	DATE
SCEND	SCEND	SCEND		

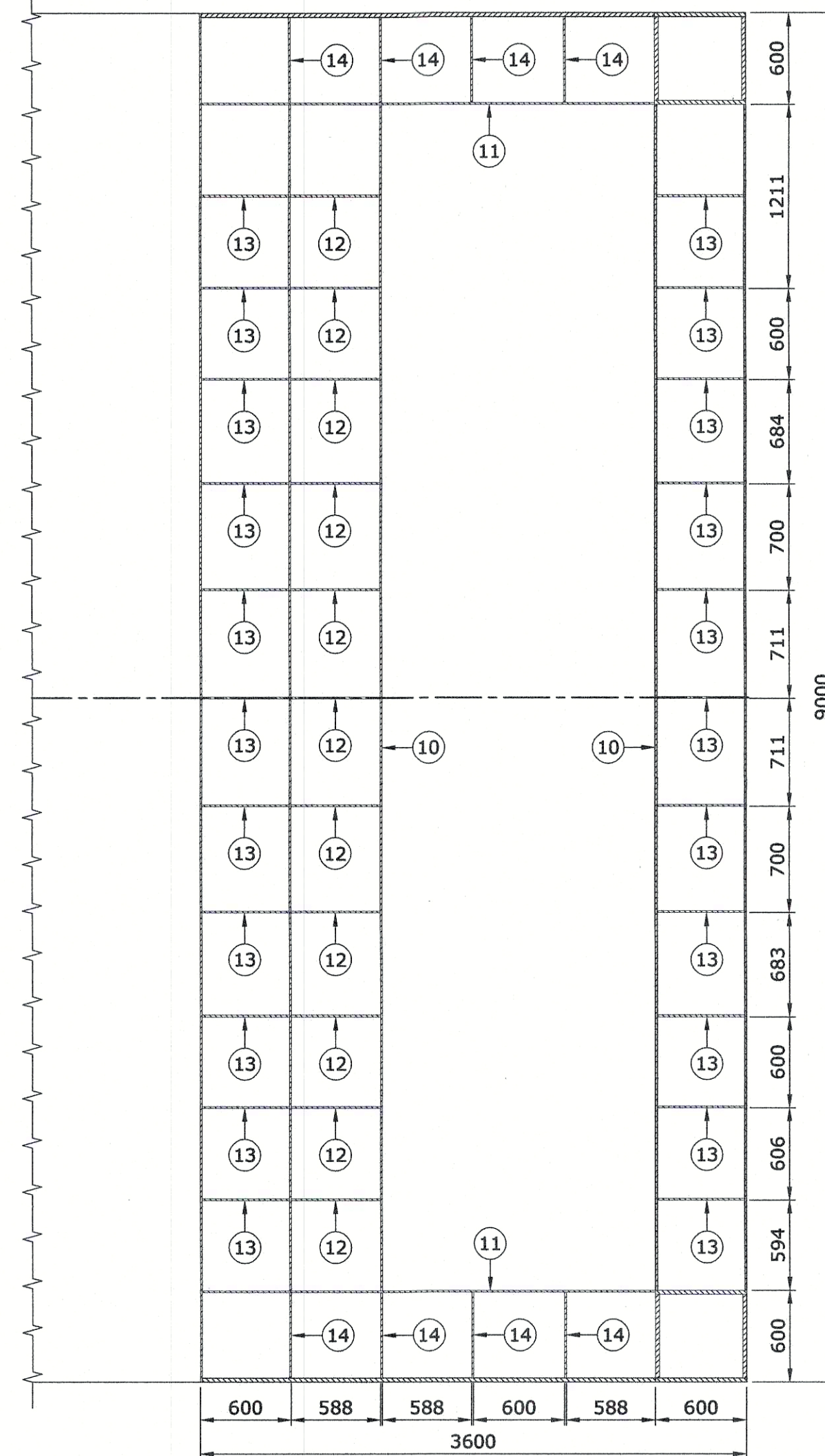
TITLE	PROJECTION
ASSEMBLY OF MOBILE LAUNCH PEDESTAL (MLP) FOR MLS (SLC PROJECT)	
GOVERNMENT OF INDIA INDIAN SPACE RESEARCH ORGANISATION SATISH DHAWAN SPACE CENTRE SHAR SRIHARIKOTA	
SCALE	SHEET
1 : 25	2
DRG. NO.	OF
10-STR-12-1-23/A1	14

STATUS	SIGN	DATE
DISCUSSION / REVIEW		
TENDER PURPOSE		
FABRICATION		
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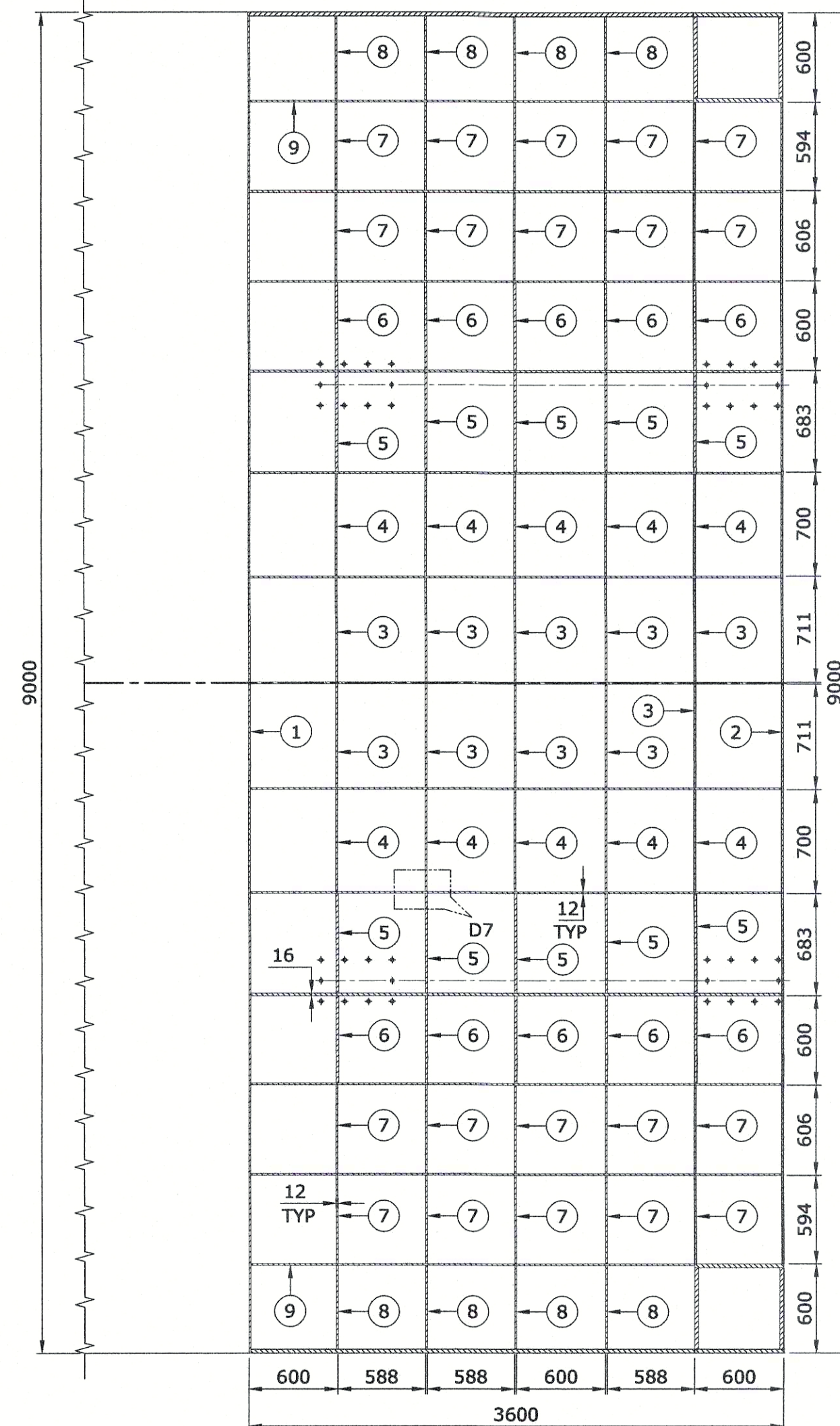
DO NOT SCALE THE DRAWING	DEVIATION FOR NON TOLERANCED DIMENSIONS (IS -2102)
ASK IF IN DOUBT	DIAMETERS & LENGTHS
UNLESS OTHERWISE SHOWN	UPTO & INCL 6 ±0.1
ALL DIMENSIONS ARE IN MILLIMETERS	6 - 30 ±0.2
REMOVE SHARP EDGES & BURRS	30 - 120 ±0.3
CHAMFER 1 M.M. X 45°	120 - 315 ±0.5
MACHINING FINISH IN MICRONS :-	315 - 1000 ±0.8
▽ 8 - 25	1000 - 2000 ±1.2
▽▽ 0.025 - 1.6	2000 - 4000 ±2.0
▽▽▽ 1.6 - 8	4000 & ABOVE ±3.0
▽▽▽▽ < 0.025	LENGTH IN M.M. OF SHORTER SIDE OF ANGLE UPTO & INCL
	1- 6 ± 1'-00
	6- 30 ± 0'-30
	30-120 ± 0'-20
	120-400 ± 0'-10



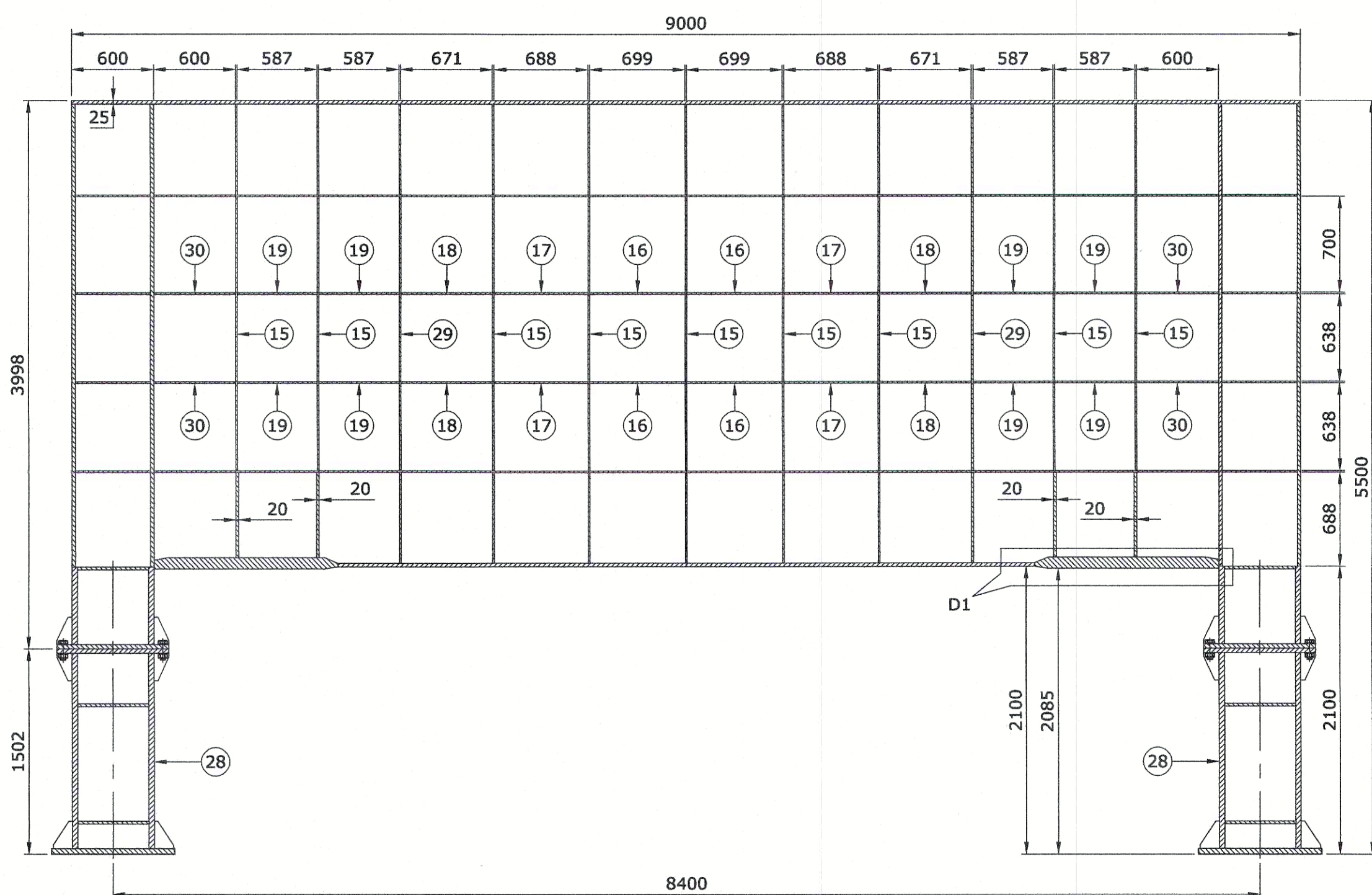
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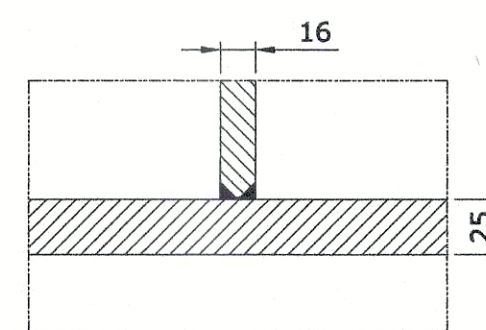
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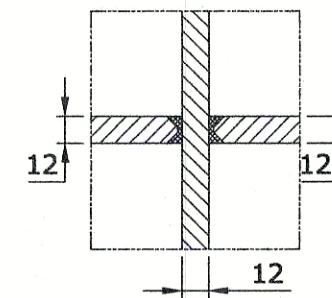
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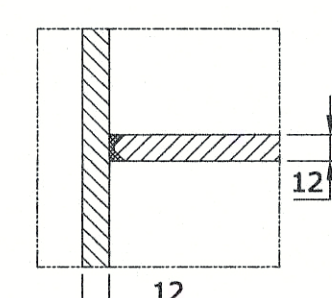
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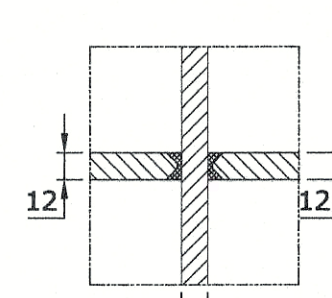
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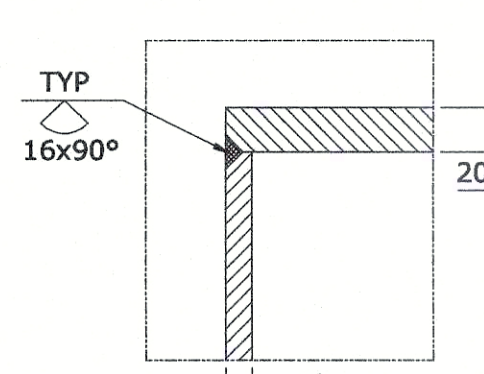
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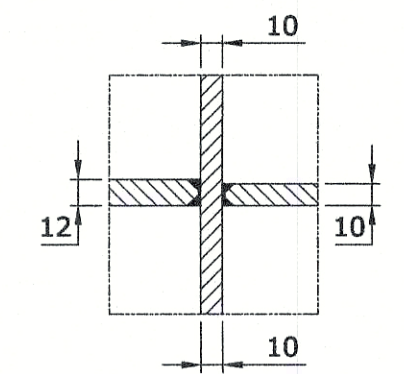
DETAIL : D3



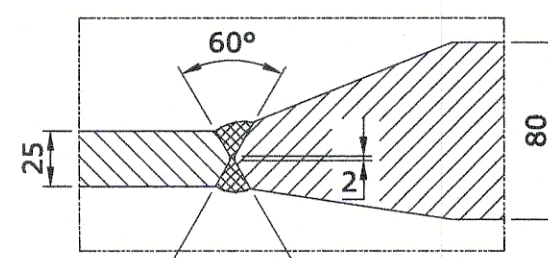
DETAIL : D7



DETAIL : D5



DETAIL : D4



BUTT WELD

TOTAL WEIGHT 245672 kg(Approx.)					
30	PLATE 600 x 578 x 12Thk	IS : 2062 E250 Gr : B	4	131	
29	PLATE 2000 x 578 x 14Thk	IS : 2062 E250 Gr : B	2	254	
28	DETAILS OF MLP LEG	-	1	15933	REFER SHEET NO : 9 OF 14
27	CENTRAL ANNULAR STRUCTURE	-	1	30960	REFER SHEET NO : 8 OF 14
26	DETAILS OF TOP DECK	-	1	55239	REFER SHEET NO : 7 OF 14
25	DETAILS OF BOTTOM DECK	-	1	64172	REFER SHEET NO : 6 OF 14
24	SECTIONAL DETAILS OF S5-S5 & S6-S6 OF MLP	-	1	15043	REFER SHEET NO : 5 OF 14
23	SECTIONAL DETAILS OF S8-S8 OF MLP	-	1	49272	REFER SHEET NO : 4 OF 14
22	PLATE 700 x 572 x 12Thk	IS : 2062 E250 Gr : B	48	1810	
21	PLATE 700 x 578 x 12Thk	IS : 2062 E250 Gr : B	48	1829	
20	PLATE 700 x 588 x 12Thk	IS : 2062 E250 Gr : B	24	931	

19	PLATE 587 x 578 x 12Thk	IS : 2062 E250 Gr : B	8	256	
18	PLATE 671 x 578 x 12Thk	IS : 2062 E250 Gr : B	4	146	
17	PLATE 688 x 578 x 12Thk	IS : 2062 E250 Gr : B	4	150	
16	PLATE 700 x 578 x 12Thk	IS : 2062 E250 Gr : B	4	152	
15	PLATE 2000 x 578 x 12Thk	IS : 2062 E250 Gr : B	9	980	
14	PLATE 700 x 563 x 12Thk	IS : 2062 E250 Gr : B	8	297	
13	PLATE 700 x 576 x 12Thk	IS : 2062 E250 Gr : B	22	836	
12	PLATE 700 x 588 x 12Thk	IS : 2062 E250 Gr : B	11	426	
11	PLATE 2988 x 700 x 12Thk	IS : 2062 E250 Gr : B	2	394	
10	PLATE 7800 x 700 x 12Thk	IS : 2062 E250 Gr : B	2	1029	
9	PLATE 2988 x 650 x 12Thk	IS : 2062 E250 Gr : B	2	366	
8	PLATE 564 x 650 x 12Thk	IS : 2062 E250 Gr : B	8	276	
7	PLATE 594 x 650 x 12Thk	IS : 2062 E250 Gr : B	20	727	
6	PLATE 588 x 650 x 16Thk	IS : 2062 E250 Gr : B	10	480	
5	PLATE 672 x 650 x 16Thk	IS : 2062 E250 Gr : B	10	549	
4	PLATE 688 x 650 x 12Thk	IS : 2062 E250 Gr : B	10	421	
3	PLATE 700 x 650 x 12Thk	IS : 2062 E250 Gr : B	10	429	
2	PLATE 7800 x 1380 x 12Thk	IS : 2062 E250 Gr : B	1	1014	
1	PLATE 9000 x 1380 x 12Thk	IS : 2062 E250 Gr : B	1	1170	
S.NO	DESCRIPTION	MATERIAL	QTY	W.T	REMARKS

NOTES:-

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4. ALL WELDS ARE TO BE DP TESTED FOR ROOT AND FINAL PASSES TO ENSURE WELD QUALITY.
5. ALL BUTT WELD JOINTS SHALL BE 100% R.T CHECKED.
6. FINAL MACHINING SHALL BE CARRIED OUT AFTER STRESS RELIEVING.
7. CHECK THE STATUS OF THE DRAWING BEFORE STARTING FABRICATION.


STATUS	SIGN	DATE
DISCUSSION / REVIEW		
TENDER PURPOSE	<i>[Signature]</i>	9/10
FABRICATION		
UNRESTRICTED	RESTRICTED	CONFIDENTIAL


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MACHINING FINISH IN MICRONS :-
▽ 8 - 25 ▽ 1.6 - 8
▽▽ 0.025 - 1.6 ▽▽▽ < 0.025

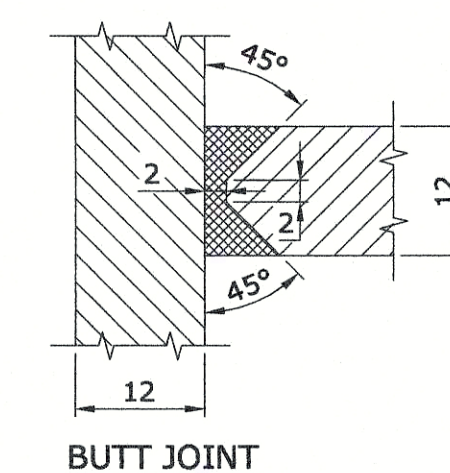
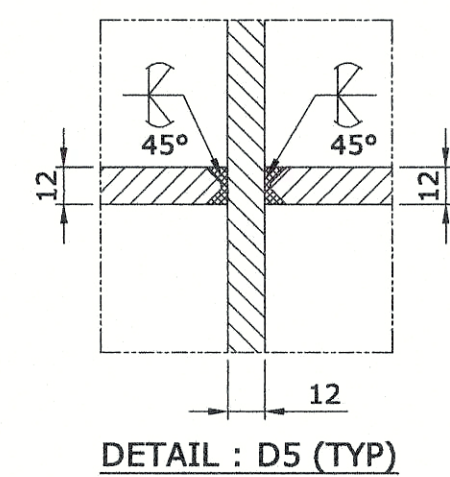
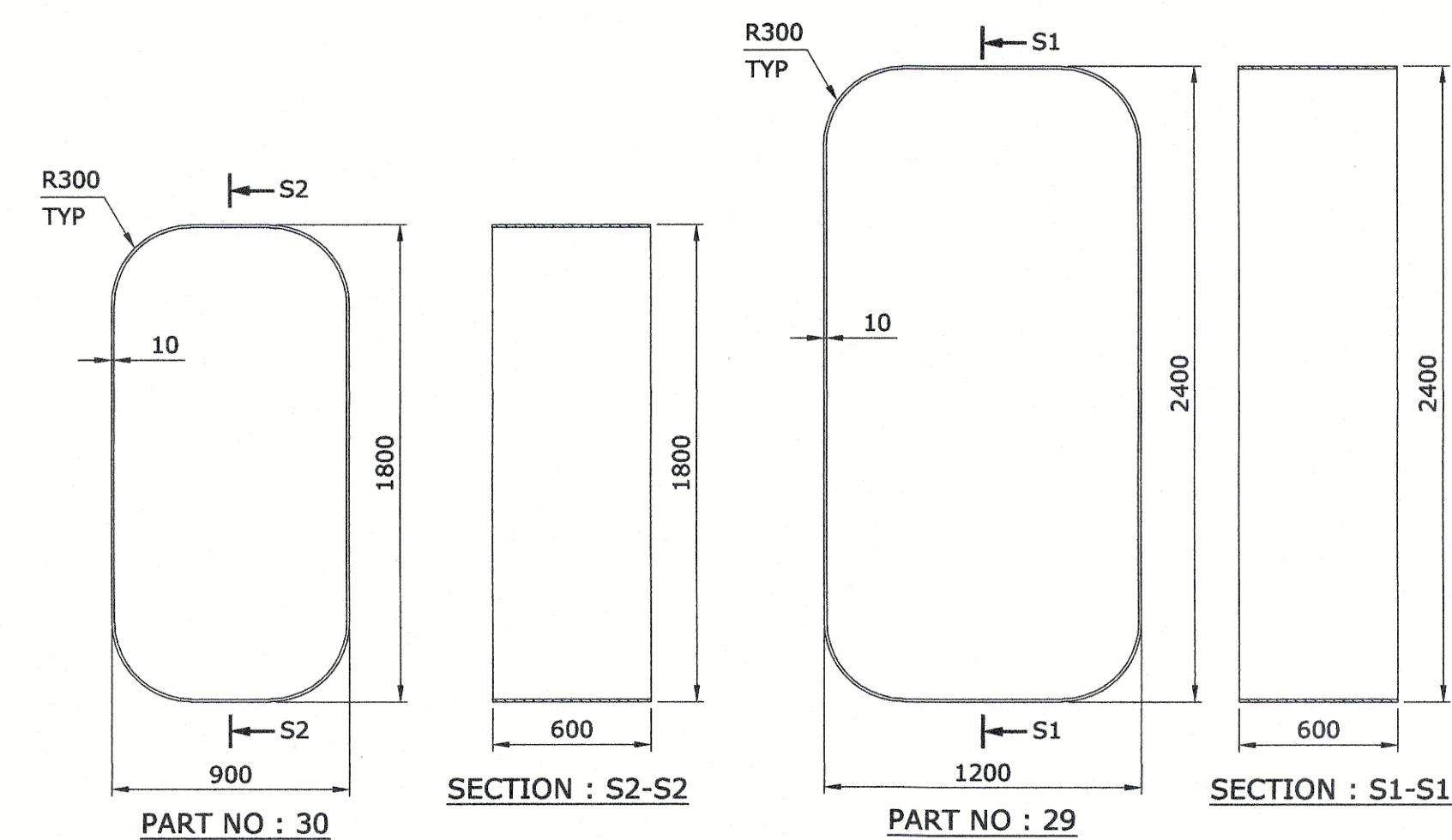
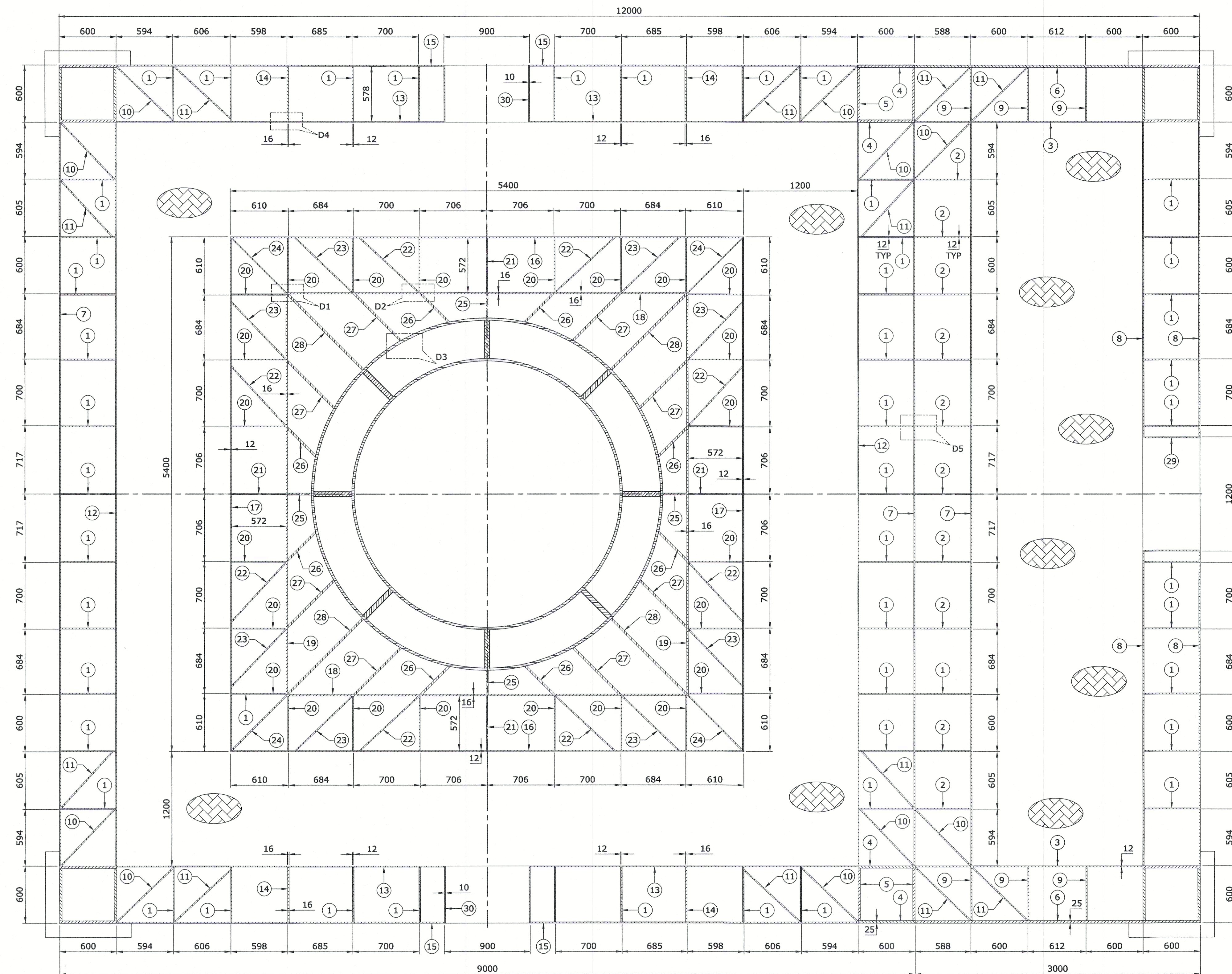
DEVIATION FOR NON TOLERANCED DIMENSIONS (IS -2102)	
DIAMETERS & LENGTHS	LENGTH IN M.M. OF SHORTER SIDE OF ANGLE UPTO & INCL
UPTO & INCL. 6 ±0.1	
6 - 30 ±0.2	
30 - 120 ±0.3	
120 - 315 ±0.5	1- 6 ± 1'-00'
315 - 1000 ±0.8	6- 30 ± 0'-30'
1000 - 2000 ±1.2	
2000 - 4000 ±2.0	30-120 ± 0'-20'
4000 & ABOVE ±3.0	120-400 ± 0'-10'

SCEND	
SHAR CENTRAL DESIGNS	
DESIGNED	<i>[Signature]</i>
DES. CHKD	<i>[Signature]</i>
DRAWN	GREENU.P09-10-23
DRG. CHKD	<i>[Signature]</i> 9/10/23
APPROVED	<i>[Signature]</i>
SIGN.	DATE

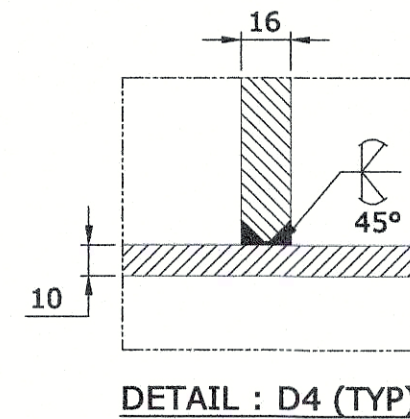
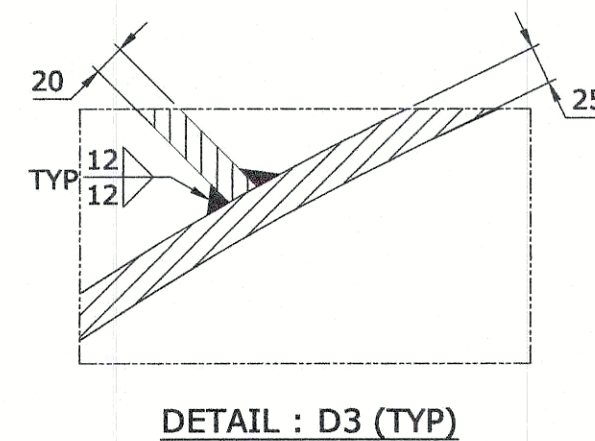
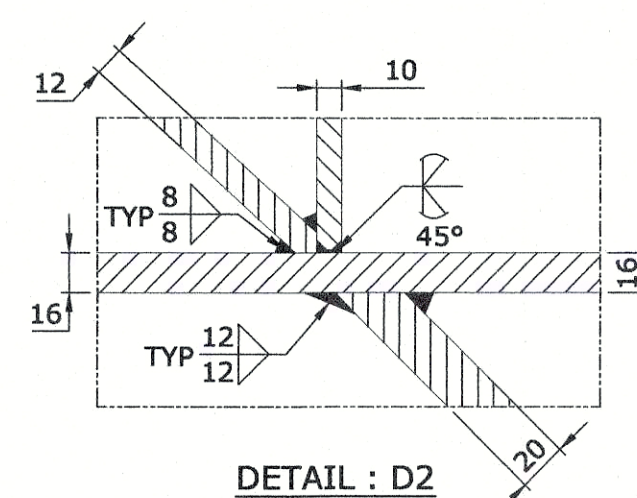
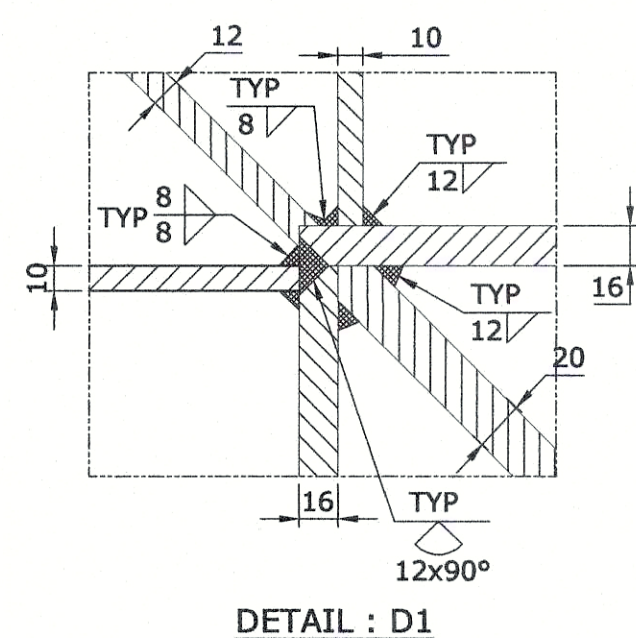
TITLE	SECTIONAL VIEW OF PEDESTAL DECK (SLC PROJECT)	
GOVERNMENT OF INDIA INDIAN SPACE RESEARCH ORGANISATION SATISH DHAWAN SPACE CENTRE SHAR SRIHARIKOTA		

PROJECTION	
	

SCALE	DRG. NO.	SHEET 3
1 : 25	10-STR-12-1-23/A1	OF 14



TOTAL WEIGHT 49272 kg(Approx.)					
30	PLATE 4885 x 600 x 10Thk	IS : 2062 E250 Gr : B	2	460	
29	PLATE 6685 x 600 x 10Thk	IS : 2062 E250 Gr : B	1	315	
28	PLATE 2000 x 1110 x 20Thk	IS : 2062 E250 Gr : B	4	1394	
27	PLATE 2000 x 697 x 20Thk	IS : 2062 E250 Gr : B	8	1751	
26	PLATE 2000 x 420 x 20Thk	IS : 2062 E250 Gr : B	8	1055	
25	PLATE 2000 x 250 x 20Thk	IS : 2062 E250 Gr : B	4	314	
24	PLATE 2000 x 810 x 12Thk	IS : 2062 E250 Gr : B	4	610	
23	PLATE 2000 x 830 x 12Thk	IS : 2062 E250 Gr : B	8	1251	
22	PLATE 2000 x 845 x 12Thk	IS : 2062 E250 Gr : B	8	1274	
21	PLATE 2000 x 572 x 12Thk	IS : 2062 E250 Gr : B	4	431	
20	PLATE 2000 x 572 x 10Thk	IS : 2062 E250 Gr : B	24	2155	
19	PLATE 2000 x 4200 x 16Thk	IS : 2062 E250 Gr : B	2	2110	
18	PLATE 2000 x 4232 x 16Thk	IS : 2062 E250 Gr : B	2	2126	
17	PLATE 2000 x 5376 x 12Thk	IS : 2062 E250 Gr : B	2	2026	
16	PLATE 2000 x 5400 x 12Thk	IS : 2062 E250 Gr : B	2	2035	
15	PLATE 2000 x 3450 x 12Thk	IS : 2062 E250 Gr : B	4	2600	
14	PLATE 2000 x 578 x 16Thk	IS : 2062 E250 Gr : B	4	581	
13	PLATE 2000 x 3450 x 10Thk	IS : 2062 E250 Gr : B	4	2167	
12	PLATE 2000 x 7800 x 10Thk	IS : 2062 E250 Gr : B	2	2449	
11	PLATE 2000 x 808 x 12Thk	IS : 2062 E250 Gr : B	12	1827	
10	PLATE 2000 x 824 x 12Thk	IS : 2062 E250 Gr : B	10	1552	
9	PLATE 2000 x 563 x 12Thk	IS : 2062 E250 Gr : B	6	636	
8	PLATE 3300 x 2000 x 12Thk	IS : 2062 E250 Gr : B	4	2487	
7	PLATE 7800 x 2000 x 12Thk	IS : 2062 E250 Gr : B	3	4409	
6	PLATE 2000 x 2400 x 25Thk	IS : 2062 E250 Gr : B	2	1884	
5	PLATE 2000 x 550 x 25Thk	IS : 2062 E250 Gr : B	4	864	
4	PLATE 2000 x 600 x 25Thk	IS : 2062 E250 Gr : B	4	942	
3	PLATE 2000 x 2400 x 12Thk	IS : 2062 E250 Gr : B	2	904	
2	PLATE 2000 x 588 x 12Thk	IS : 2062 E250 Gr : B	11	1219	
1	PLATE 2000 x 578 x 12Thk	IS : 2062 E250 Gr : B	50	5445	
S.NO	DESCRIPTION	MATERIAL	QTY	W.T	REMARKS



- NOTES:-**
1. ALL DIMENSIONS SHOWN ARE FINISHED DIMENSIONS.
 2. ALL PLATES ABOVE 20mm THICK SHALL BE UT TESTED.
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STATUS		SIGN	DATE
DISCUSSION / REVIEW			
TENDER PURPOSE		<i>Don</i>	<i>9/10/23</i>
FABRICATION			
UNRESTRICTED	RESTRICTED	CONFIDENTIAL	
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DEVIATION FOR NON TOLERANCED DIMENSIONS (IS -2102)	
DIAMETERS & LENGTHS	LENGTH IN M.M. OF SHORTER SIDE OF ANGLE UPTO & INCL
UPTO & INCL. 6 ±0.1	
6 - 30 ±0.2	
30 - 120 ±0.3	
120 - 315 ±0.5	1 - 6 ± 1°-00'
315 - 1000 ±0.8	6 - 30 ± 0°-30'
1000 - 2000 ±1.2	30 - 120 ± 0°-20'
2000 - 4000 ±2.0	120-400 ± 0°-10'
4000 & ABOVE ±3.0	


SCEND	
SHAR CENTRAL DESIGN	
DESIGNED	<i>[Signature]</i>
DES.CHKD	<i>[Signature]</i>
DRAWN	GREENUP 09-10-
DRG.CHKD	<i>[Signature]</i> 9/10/20
APPROVED	<i>[Signature]</i>

TITLE	SECTIONAL DETAILS OF S8-S8 OF MLP (SLC PROJECT)
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**GOVERNMENT OF INDIA
INDIAN SPACE RESEARCH ORGANISATION
SATISH DHAWAN SPACE CENTRE SHAR
SRIHARIKOTA**

SCALE 1 : 25

DRG. NO.	10-STR-12-1-23/A1
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PROJECTION	
	
SHEET	4